


3

Date: Thursday, 12/20/2007 3:17:20 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 205 DUAL MIRROR ASSEMBLY
Job Number : 36467	
Estimate Number : 10149	
P.O. Number :	Part Number : D205563041
This Issue : 12/20/2007 S.O. No. :	Drawing Number : D2161 REV B2
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : SMALL /MED FAB	Drawing Revision : B2
Previous Run : 28218	Material :
Written By :	Due Date : 1/15/2008 Qty:  Each
Checked & Approved By : <u>1207.12.21</u>	
Comment : Est Rev:1 Removed Manufacturing 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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KS 08.01.10

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD205-563-041 CHG003

5 08/01/08

2.0	36467A	MIRROR BRACKET
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Comment: Sub-Component MIRROR BRACKET

D2161-205 B 36467A

PC 8/01/08

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

4.0	D2011103	Mirror 8"
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

2 D2011-103

Mirror

29690 6 Y

36506 2 X PC 8/01/08 SQ

5.0	D2161205	Mirror Bracket, 205
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 D2161-205

Mirror Bracket

336467A

PC 8/01/08 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:17:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 205 DUAL MIRROR ASSEMBLY

Job Number: 36467

Part Number: D205563041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS27039108

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 MS27039-1-08 Screw

M105076

1 Package of paperwork

8/1/3 SP (4x) 50

7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

02/01/08 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-563-041

Location: B

8/1/28 50 (4)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4) 2008/01/29

Job Completion



mi 2008/1/28

U

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

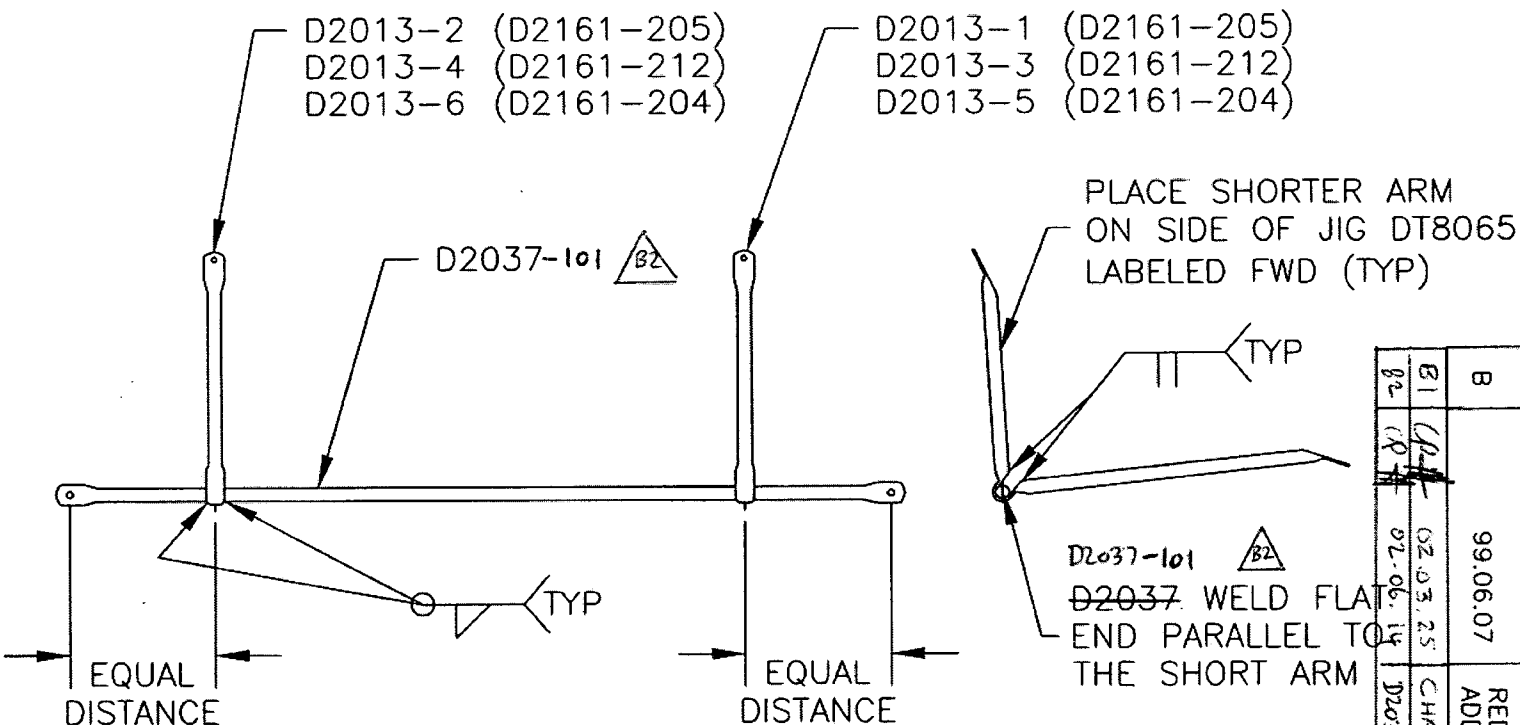
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries


DESIGN	JB	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. B
CHECKED	<i>KE</i>	APPROVED	DRAWING NO.	D2161	SHEET 1 OF 1
DATE	99.06.07		TITLE		SCALE
A		93.04.29	MIRROR BRACKET		NTS
B		99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS		
B1	9-1	02.03.25	CHANGE FINISH		
82	18-1	02.06.14	D2037-K01 W/		

RELEASED
APR 29 06 10



DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

H: ~~POWDER COAT ASSEMBLY BLACK~~
SPRINKLE (4.3.5.3) PER DART QSI 005 4.3
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3 

ENGINEERING
UNCONTROLLED COPY
SUSJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

る

Date: Thursday, 12/20/2007 3:17:24 PM
 User: Kim Johnston

Process Sheet

3

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MIRROR BRACKET
Job Number : 36467A	
Estimate Number : 10148	
P.O. Number :	Part Number : D2161205
This Issue : 12/20/2007 S.O. No. :	Drawing Number : D2161 REV B2
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B2
Previous Run : 28218A	Material :
Written By :	Due Date : 1/15/2008 Qty: 4 Um: Each
Checked & Approved By : <u>107-1221</u>	
Comment : Est Rev:A New Issue 05-11-01 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	36467A01	MIRROR BRACKET LH
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Comment: Sub-Component MIRROR BRACKET LH
 D2013-1 B D36467A01

FC 08 01 22 (4)

2.0	36467A02	MIRROR BRACKET RH
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Comment: Sub-Component MIRROR BRACKET RH
 D2013-2 B D36467A02

FC 08 01 22 (4)

3.0	36467A03	ARM
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Comment: Sub-Component ARM
 D2037-101 B D36467A03

FC 08 01 22 (4)

4.0	D20131	Mirror Bracket LH, 205
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2013-1 Bracket LH

N/A

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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N/A

Comment: FINAL INSPECTION/W/O RELEASE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:17:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 36467A

Part Number: D2161205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D20132

Mirror Bracket RH, 205



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2013-2 Bracket RH

N/A

7.0

D2037101

Arm, mirror



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2037-101 Bracket Center

N/A

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble on Jig DT8065 as per Dwg D2161

2-Weld as per Dwg D2161 Identify as D2161-205

FL

FL

08/01/22

(4)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-01-22 (4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspected by [Signature] 08-01-23 (4)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M-L

08/01/24

(4X)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/01/24 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: D Date: 08/01/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:17:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR BRACKET

Job Number: 36467A

Part Number: D2161205

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)
2008/11/28

Job Completion



2008/11/28
d

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

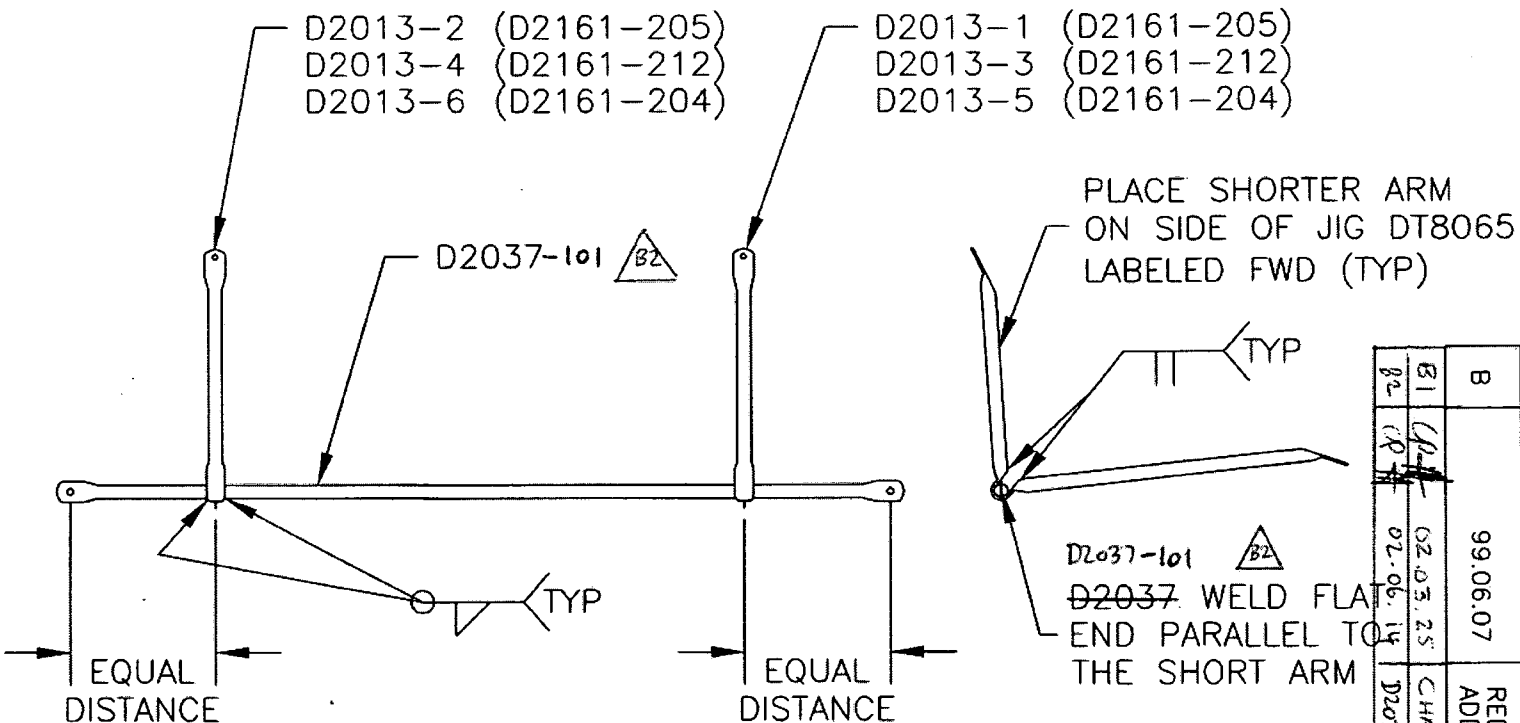
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
JB	RT		
CHECKED KE	APPROVED RT	DRAWING NO. D2161	SHEET 1 OF 1
DATE 99.06.07	TITLE MIRROR BRACKET	SCALE NTS	
A	93.04.29	NEW ISSUE	
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS	
B1	02.03.25	CHANGE FINISH	
B2	02.06.14	D2037-101 WELD	

RELEASED
KE 99.06.10



DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: POWDER COAT ASSEMBLY BLACK
SPRINKLE (4.3.5.3) PER DART QSI 005 4.3
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3
UNCONTROLLED COPY
ENGINEERING
RETURN TO
D2037-101
WORK ORDER
NO. 30467 A
SUBJECT TO AMENDMENT
WITHOUT NOTICE

Date: Wednesday, 13/02/2008 3:25:03 PM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D204-562/D205-563/D212-580
Job Number : 37409	
Estimate Number : 10804	
P.O. Number :	Part Number : Z_CUSTOM
This Issue : 13/02/2008 S.O. No. :	Drawing Number : ECN 1130
Prsht Rev. : NC	Project Number :
First Issue : // Type : SMALL /MED FAB	Drawing Revision :
Previous Run : 00015	Material :
	Due Date : 20/02/2008 Qty: 1 Um: Each
Written By :	
Checked & Approved By :	
Comment :	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

PULL FROM STOCK:

D204-562-041

36466 (1x) 37235 (1x)

D205-563-041

37214 (1x) 36467 (4x) 32722 (1x)

D212-580-041

36183 (2x)

ADD NEW PAPERWORK TO KITS IN STOCK
 FAA STC SH975NE, PER ECN 1130

RETURN TO STOCK

8/2/15 50 (10x)

2.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12 08/02/19

Job Completion



U 08.02.19